

Work Order ID 68719

Wednesday, April 20, 2011 10:20:52 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 4-20-2011

Tooling:

Date:

✓

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: *M11578* 0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

[Signature] 11.06.01

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

[Signature] 11.06.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

81106602



130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time:

Oven Temperature:

Finish Time:

7:30
320°F
8:00

140

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M115128

M115863

IX ~~OK~~ M11/06/03

1 BR 11-6-3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

E/Su/06/03 @

160

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

W/O
68717

E/Su/06/03 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/16
MP
11-0607

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Picklist Print

Wednesday, April 20, 2011 10:20:58 AM

Page 1

Work Order ID: 68719

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/20/2011

Required Date: 4/25/2011


Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	20.0000	2	2		11.05.31	
---	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

Location

Loc Qty


Loc Code


WA005

20

66806

20

D3914-1  Rib		Manufactured	No			100	Each	0.0000	2	2		11.05.31	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

D3914-7  Rib		Manufactured	No			100	Each	8.0000	2	2		11.05.31	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location

Loc Qty

Loc Code

WA

1

66620

1

WA006


7

66980

3

68175

4

D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	9.0000	3	3		11.05.31	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location

Loc Qty

Loc Code

WA005

9

65951

3

67040

6

B68572

(3x)

W/O:		WORK ORDER CHANGES					
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Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No



Rib

100 Each 32.0000 9 9

5x B69013
4x B69726
Loc Qty Loc Code

Location

WA005

67041

32

32



11.05.31

D4020-5 Manufactured No



Mesh (350 Basket Long, Lid)

100 Each 2.0000 1 1

B69293 1x

Location

WA

66518

Loc Qty

2

2

Loc Code



11.06.01

D4021-3 Manufactured No



Data Plate

100 Each 5.0000 1 1

Location

WA005

65922

66721

Loc Qty

5

1

4

Loc Code



11.05.31

D4035-041 Manufactured No



Lid Rib Assembly, Fwd (350 Basket)

100 Each 6.0000 1 1

Location

WA006

67337

67374

Loc Qty

6

1

5

Loc Code



11.05.31

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 3

Wednesday, April 20, 2011 10:20:59 AM

Work Order ID: 68719



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured

No

100

Each

8.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

11.05.31

Location

Loc Qty

Loc Code

WA006

8

67336

2

67375

6

D2728-3

Manufactured

No

140

Each

0.0000

1

1



Dart Logo label

Wednesday, April 20, 2011 10:20:59 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

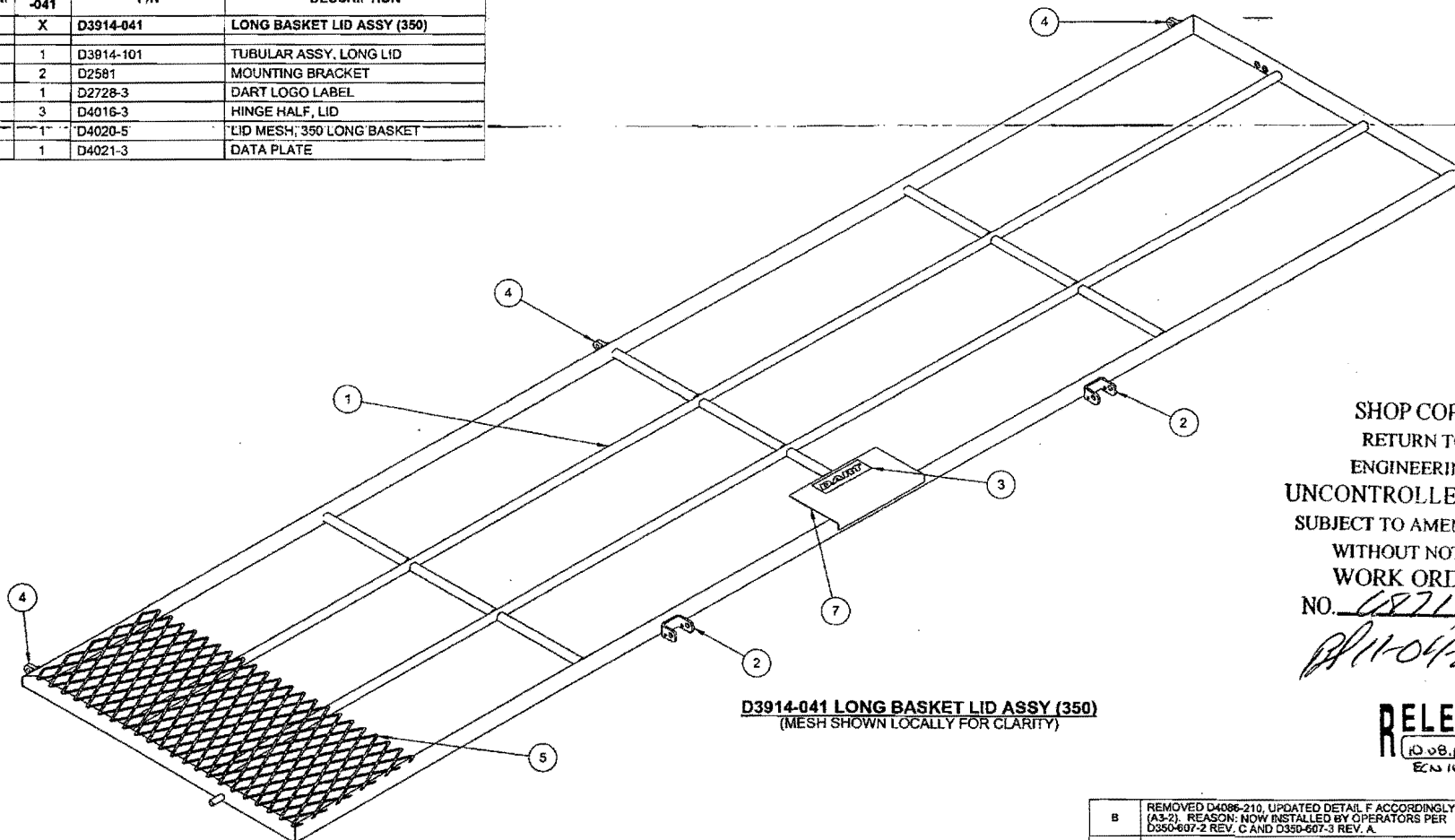
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 68719

PH 11-04-20

RELEASED
10-08-17
E2 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>		
MFG. APPR.	<i>SC</i>		
APPROVED	<i>SC</i>		
DE APPR.	<i>SC</i>		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 REV. B SHEET 1 OF 4 TITLE LONG BASKET LID ASSY (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

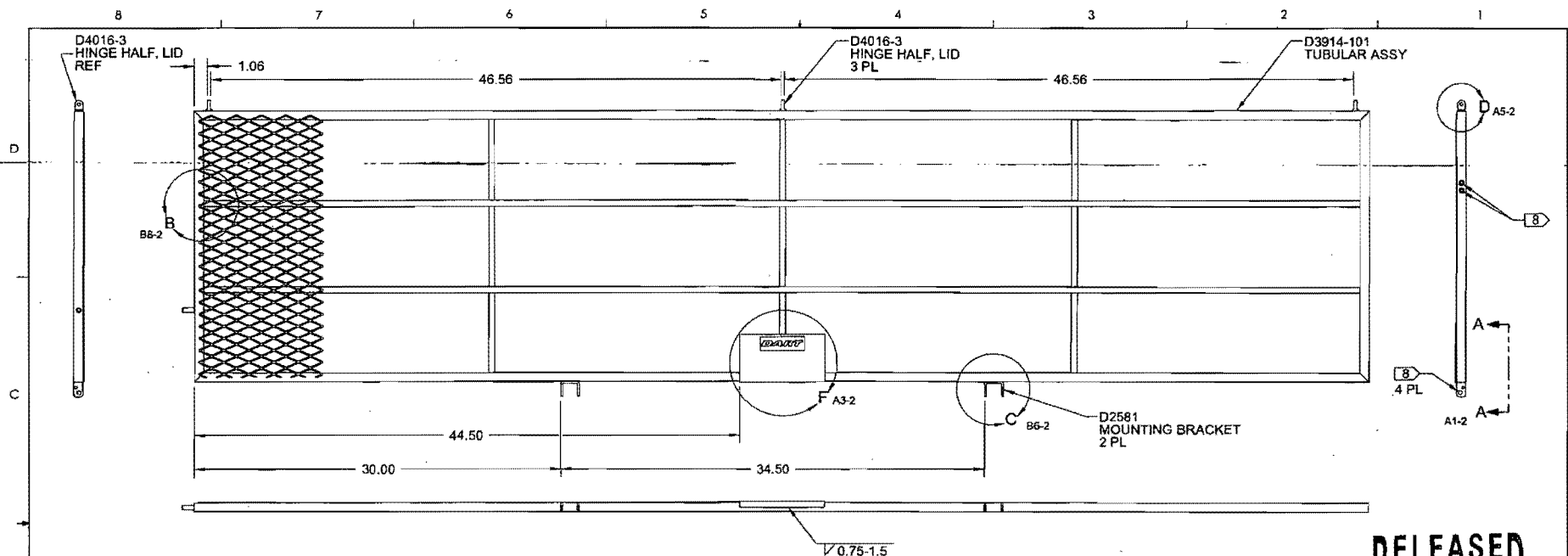
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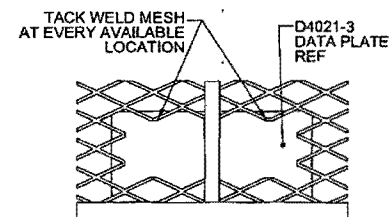
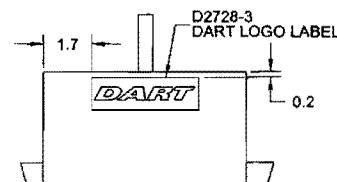
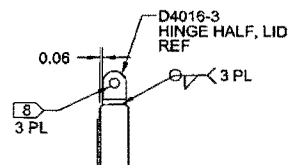
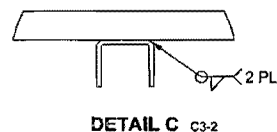
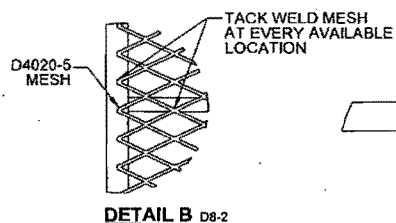
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NOTE: Date & initial all entries



RELEASED
10.08.12 UP

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

w/o 68719

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3914	SHEET 2 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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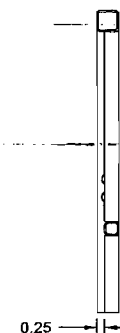
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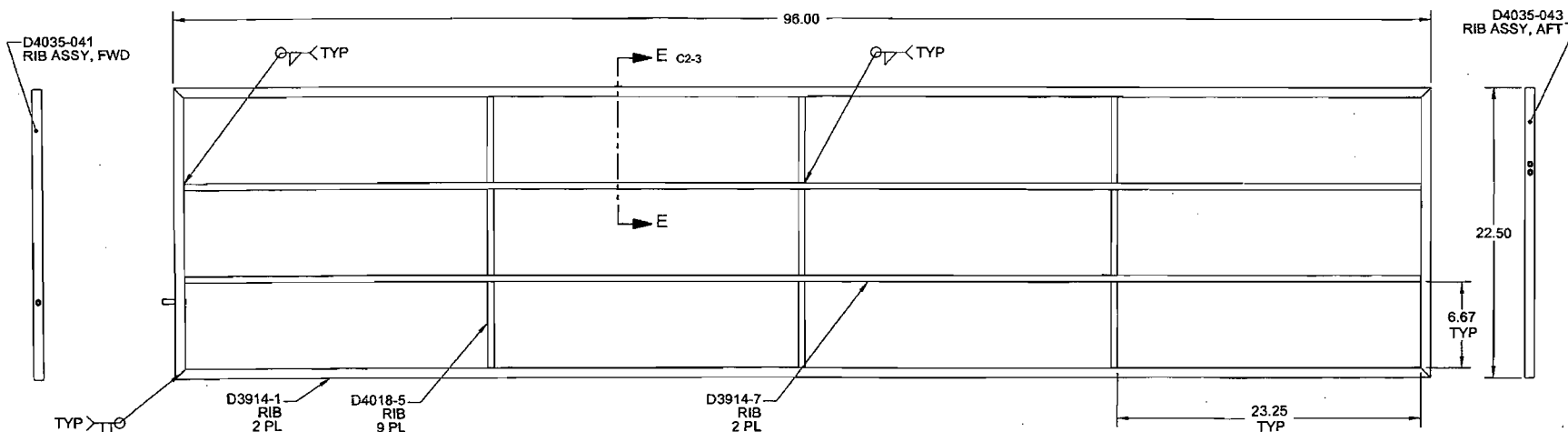
NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

u/o 68719



SECTION E-E C5-3



(B) D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

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DRAWN	RC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RC	DRAWING NO.	REV. B
MFG. APPR.	RC	D3914	SHEET 3 OF 4
APPROVED	RC	TITLE	SCALE
DE APPR.	RC	LONG BASKET LID ASSY (350)	NTS
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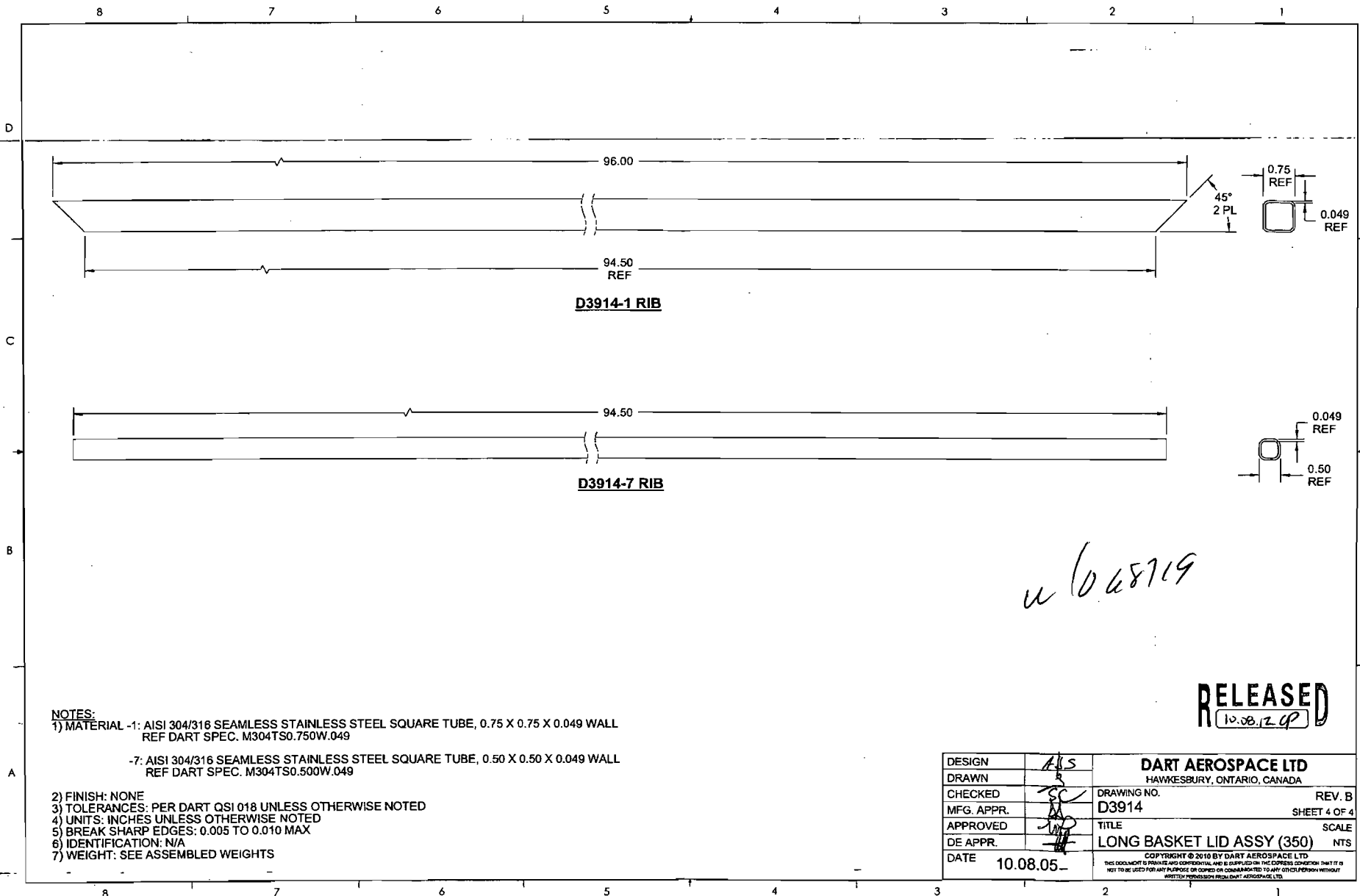
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RELEASED
10.08.12 GP

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 4 OF 4
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